

Date: Wednesday, 1/30/2008 8:01:59 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM	
Job Number	: 37098		Part Number	: D36461	
Estimate Number	: 12973		Drawing Number	: D3646 REV.A	
P.O. Number	:		Project Number	: N/A	
This Issue	: 1/30/2008	S.O. No. :	Drawing Revision	: A	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 2/8/2008	
Previous Run	: 34321		Qty:	4	Um: Each
Written By	:				
Checked & Approved By	:				
Comment	: Est Rev A new issue 07.07.25 EC verified by:JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 2.0790 f(s)/Unit Total : 8.3160 f(s)

Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)

Batch: M107098

SB

08/02/12

(4)

(4)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch to length as per Dwg D3646 & template DT8958

SB 08/02/12

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

08/02/12 (4)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/02/12 (4)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-1 08/02/13

(4X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: ARM
Job Number: 37098		Part Number: D36461
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>MJ</i> 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		08-02-13 
7.0	PACKAGING 1 	PACKAGING RESOURCE #1 <i>0350-561-143</i> 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST 226</i>		<i>AS 08/02/14 (X4)</i>
8.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i>P 08/02/15</i>
Job Completion 		<i>min 2008/2/14 (4)</i> <i>W</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

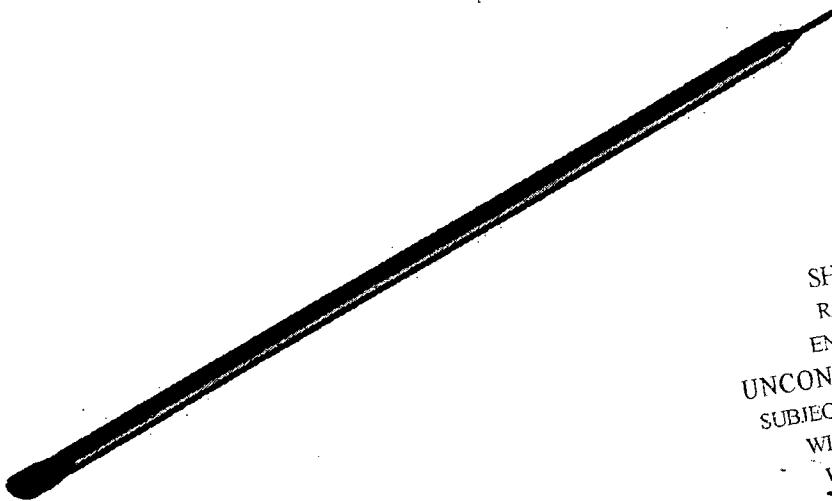
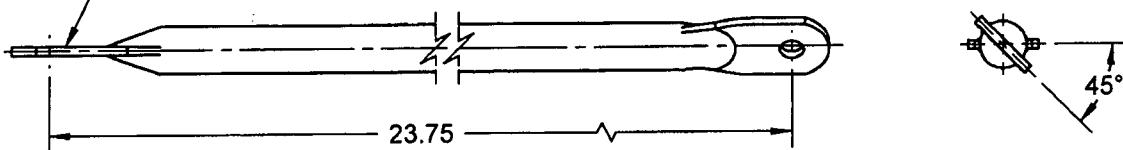
NOTE: Date & initial all entries

DART

DESIGN <i>BS</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3646	REV. A	SHEET 1 OF 2
DATE 07.06.06		TITLE ARM	SCALE 1:2	
REV A	DATE 07.06.06	DESCRIPTION NEW ISSUE		

RELEASED07.07.11 *MM*

PUNCH BOTH ENDS PER
DART SPEC CONTROL
DRAWING D2727



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37098*

D3646-1 ARM**NOTES:**

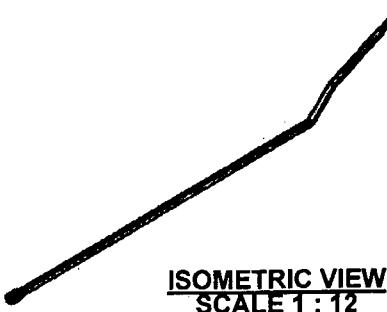
- 1) MAKE PER TEMPLATE DT8958
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART

DESIGN <i>BS</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>ST</i>	DRAWING NO. D3646	REV. A SHEET 2 OF 2
DATE 07.06.06	TITLE ARM	SCALE 1:8	

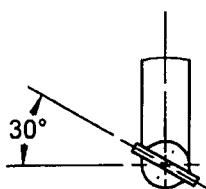
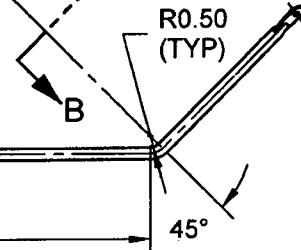


ISOMETRIC VIEW
SCALE 1:12

5.75±0.13
15°
2.50±0.13

VIEW B-B

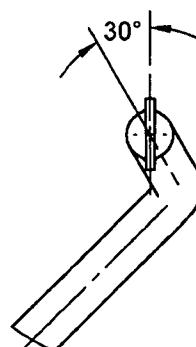
PUNCH BOTH ENDS PER
DART SPEC CONTROL
DRAWING D2727



DETAIL A
SCALE 1:2

RELEASED

07-07-01 *BS*



VIEW C-C
SCALE 1:2

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37098*

D3646-3 ARM

NOTES:

- 1) MAKE PER TEMPLATE DT8959
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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